

43

Date: Tuesday, 10/2/2007 10:43:57 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	COVER	
Job Number	34941C				
Estimate Number	10302				
P.O. Number	N/A		Part Number	D32391	
This Issue	10/2/2007	S.O. No.	S.O. No.	N/A	
Prsht Rev.	NC	Type	MACHINED PARTS	Drawing Number	D3239 REV A
First Issue	N/A			Project Number	N/A
Previous Run	32816C			Drawing Revision	A
Written By	JLM 07-10-02		Material	N/A	
Checked & Approved By			Due Date	10/22/2007	
Comment	Est Rev: A New Issue 05-11-06 JLM		Qty:	8	Um: Each
	Est: b 06.11.15 waterjet EC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S050	6061-T6 .050 Sheet
		Comment: Qty.: 0.1890 sf(s)/Unit Total : 1.5120 sf(s) Material: 6061-T6 (QQ-A-250/11) 0.050" thick (M6061T6S0.050) Identify for D3239-1 Batch: M103321 HB 07-10-4
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3239 Dwg Rev: A Prog Rev: A HB 07-10-4
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D32391 PAR #: 11A Fault Category: Prod/Fab. ass' NCR: Yes/No DQA: Date: 07/10/12  
 QA: N/C Closed: Date: 07.10.12

NCR: 34941 C		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.10.04	1.0	2024-T3 USED INSTEAD OF 6061-T6 R.C. Human error. Buller mat. with no mat. description on it	LE 07.10.04 QSI042	ACCEPTABLE. NOT DETRIMENTAL TO PERFORMANCE	LE 07.10.04 QSI042	ES 07.10.04	LE 07.10.04 QSI042	ES 07.10.04

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

Job Number: 34941C

Part Number: D32391

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS 0-1-10-11 (8)

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/10/11 59 (8X)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7/10/11 56 (8Y)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

207/10/12 (8)

Job Completion



MS 0-10-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34941C
Description: Cover	Part Number:	D3239-1
Inspection Dwg: D3239 Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## **X First Article      □ Prototype**

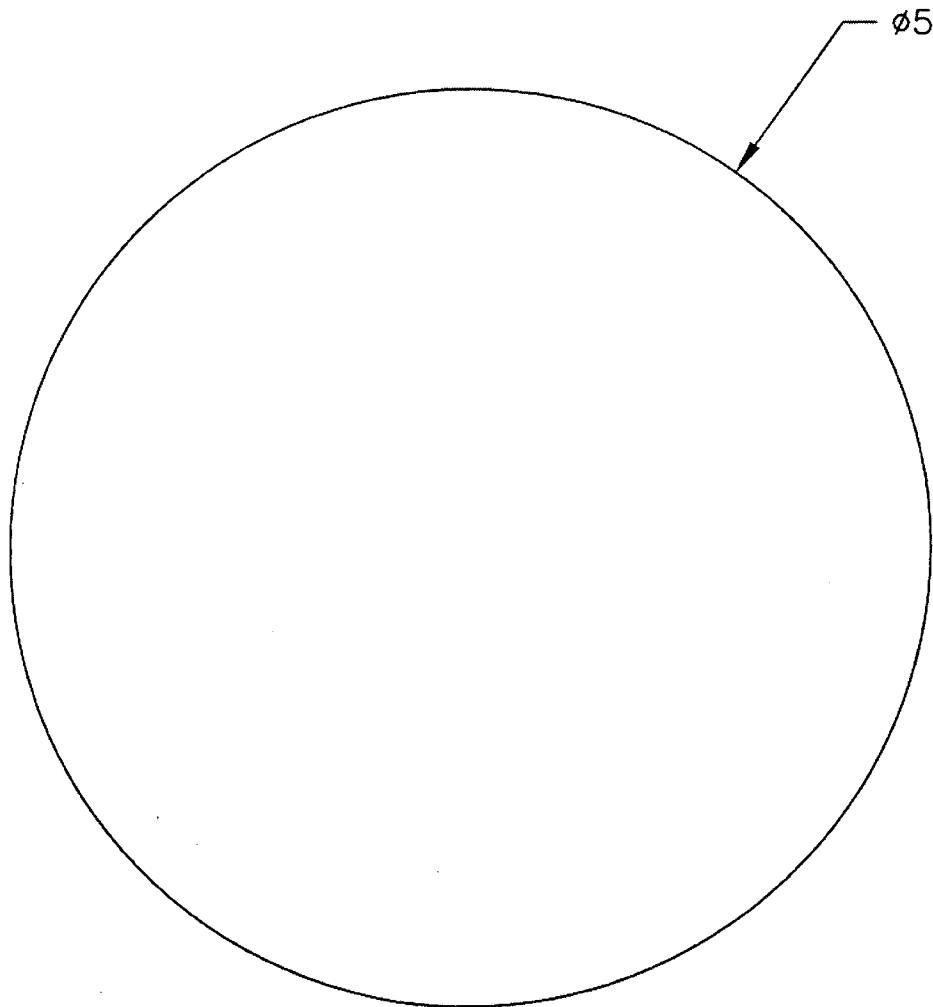
Measured by:	<u>HB</u>	Audited by:	<u>EN</u>	Prototype Approval:	N/A
Date:	07-10-4	Date:	<u>10/10/04</u>	Date:	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	04.10.05	New Issue	P/O D412-709-011	KJ/JLM <i>[Signature]</i> <i>[Signature]</i>



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3239
DATE	03.12.19	TITLE COVER
A	03.12.19	SCALE 1:1 NEW ISSUE

RELEASED  
04.02.03



Ø5.00

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER

NO. 34941 C

D3239-1 COVER

- 1) MATERIAL: 6061-T6 (QQ-A-250/11), 0.050 THICK (REF. M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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